

Date: Tuesday, 24/06/2008 2:17:54 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MIRROR ARM
<b>Job Number</b> : 40046	
<b>Estimate Number</b> : 10335	
<b>P.O. Number</b> :	<b>Part Number</b> : D2010104
<b>This Issue</b> : 24/06/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2010 REVD
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 39823	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 27/06/2008 <b>Qty:</b> 75 Um: Each
<b>Checked &amp; Approved By</b> : JW 08.06.24	
<b>Comment</b> : Est A 04.02.17 New issue KJ/JLM	
Est Rev:B 08-05-27 as per ECN1195P DD verified by:EC	
Est Rev:C 08-06-20 rev.D as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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**Comment:** Qty.: 1.5750 f(s)/Unit Total : 94.5000 f(s)  
 Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall  
 (M304TR0500W049)

Batch No: H 108324

SB 08/06/25 (75)

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC  
 Punch per Dwg. D2010-104 and Spec Control Dwg D2727  
 Identify as D2010-104

SB 08/06/25 (75)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 1- Bend as per Dwg D2010 using bending Jig D2010-104T2  
 2- Deburr ends

FF 08-06-25 (75)

B 08/06/25

4.0	D2057	Plug
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)  
 Plug  
 batch: B39826 (x17) / B40048 (x58)

FF 08-06-27 75

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- flare before installing plug as per dwg D2010

FF 08-06-27 (75)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 24/06/2008 2:17:54 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 40046

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Install D2057 plug as per Dwg D2010

PF 08-06-27

(75)

6.0

QC5

INSPECT WORK TO CURRENT STEP



08/06/27 (75)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



m162316



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:40

OVEN TEMPERATURE:

320

FINISH TIME:

9:10

1<sup>st</sup> rack  
2<sup>nd</sup> rack  
start time 8:55  
oven temp 320  
finish time 9:23

3<sup>rd</sup> rack  
start time 9:10  
oven temp 320  
finish time 9:40

08/07/01

RD/MLC

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BL 08-07-01

(75)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08/07/01 (75)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/02

Job Completion



UMF 08-07-02

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

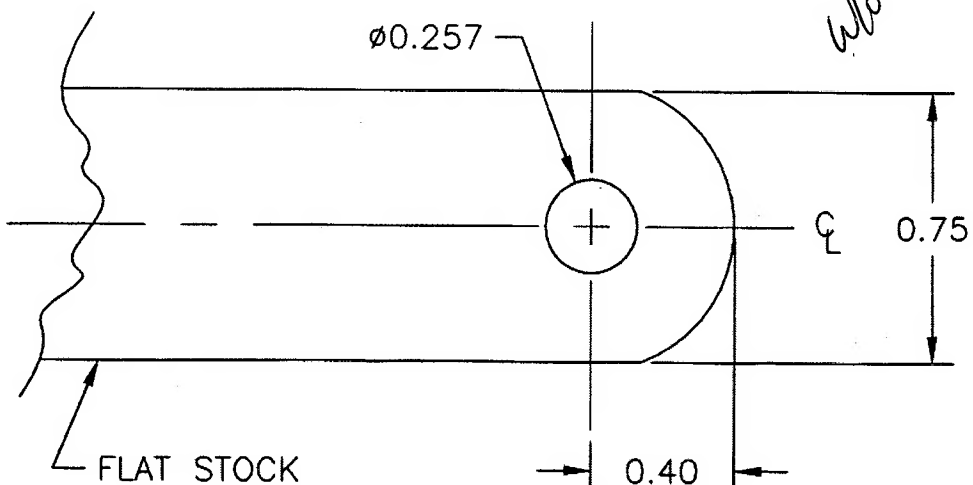
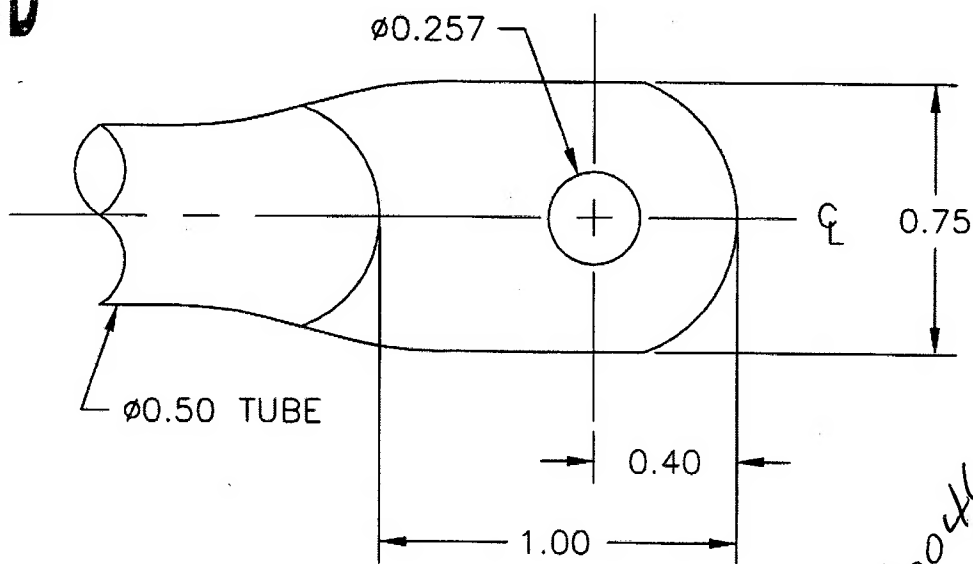
**NOTE:** Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>#CP</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8012

**RELEASED**  
98/03/06 *KE*



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



**Dart Aerospace Ltd**

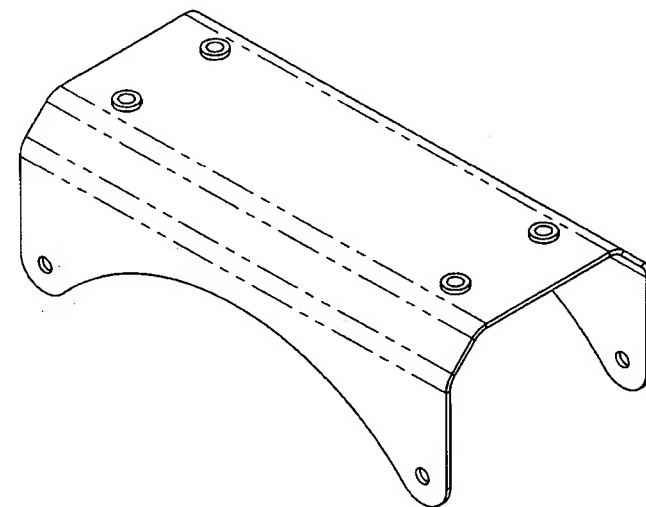
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

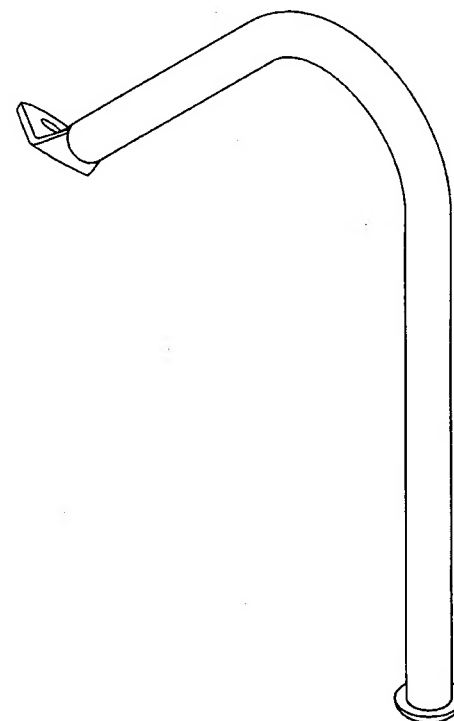
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

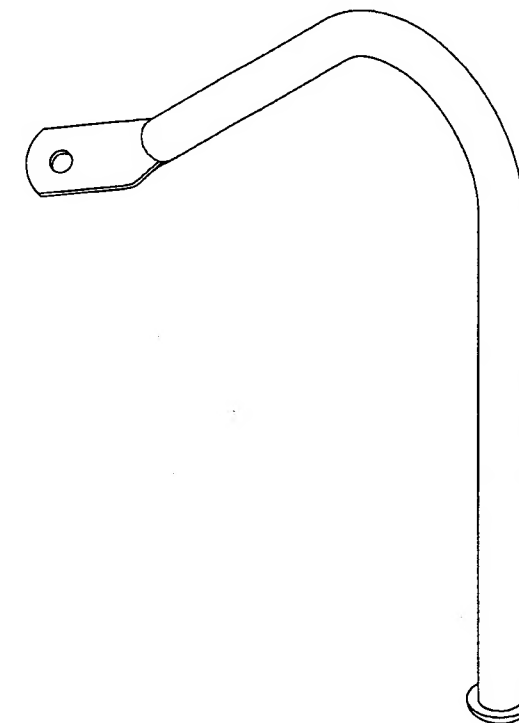
**NOTE:** Date & initial all entries



**D2010-101 MIRROR BRACKET**



**D2010-103 ARM**



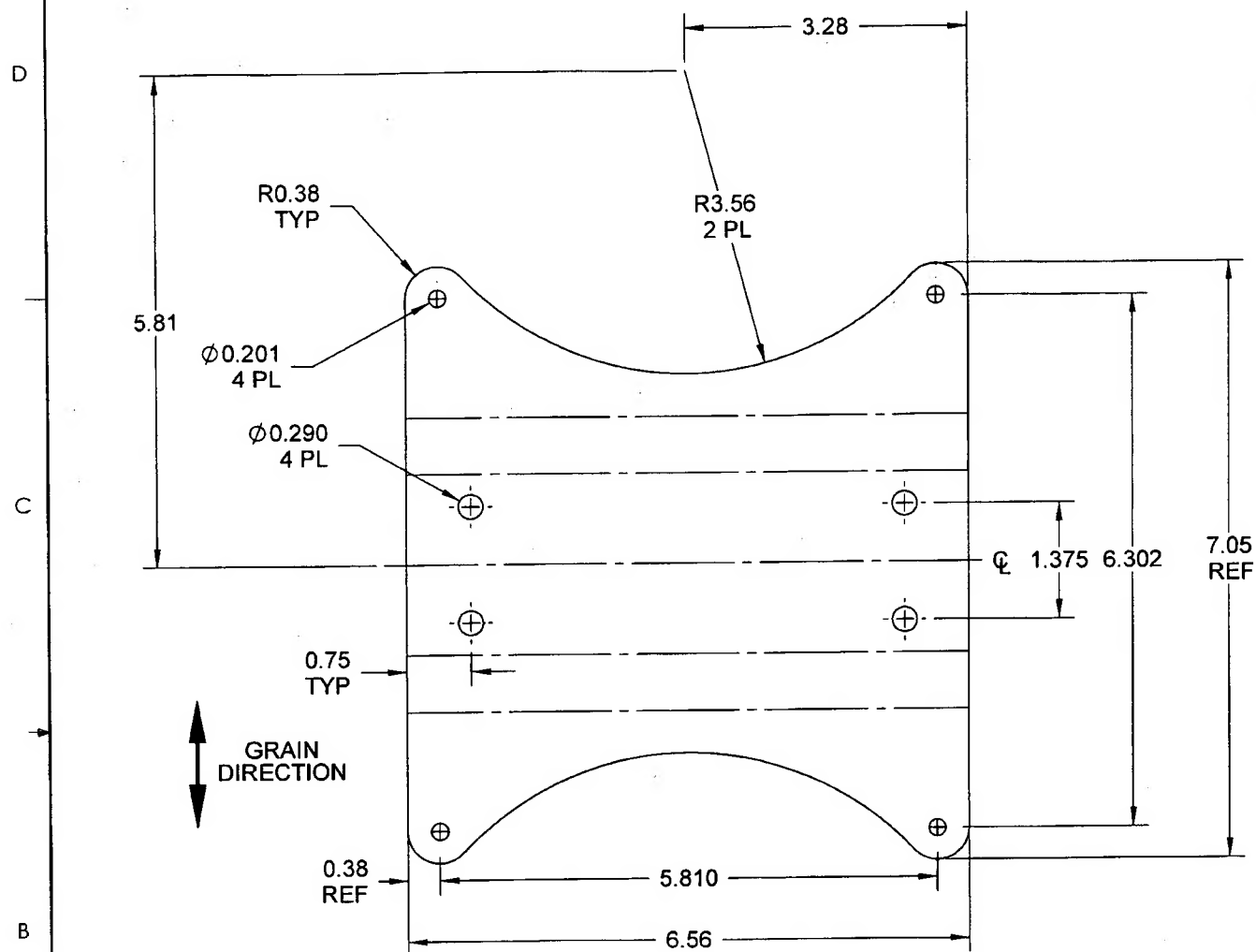
**D2010-104 ARM**

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08.06.10

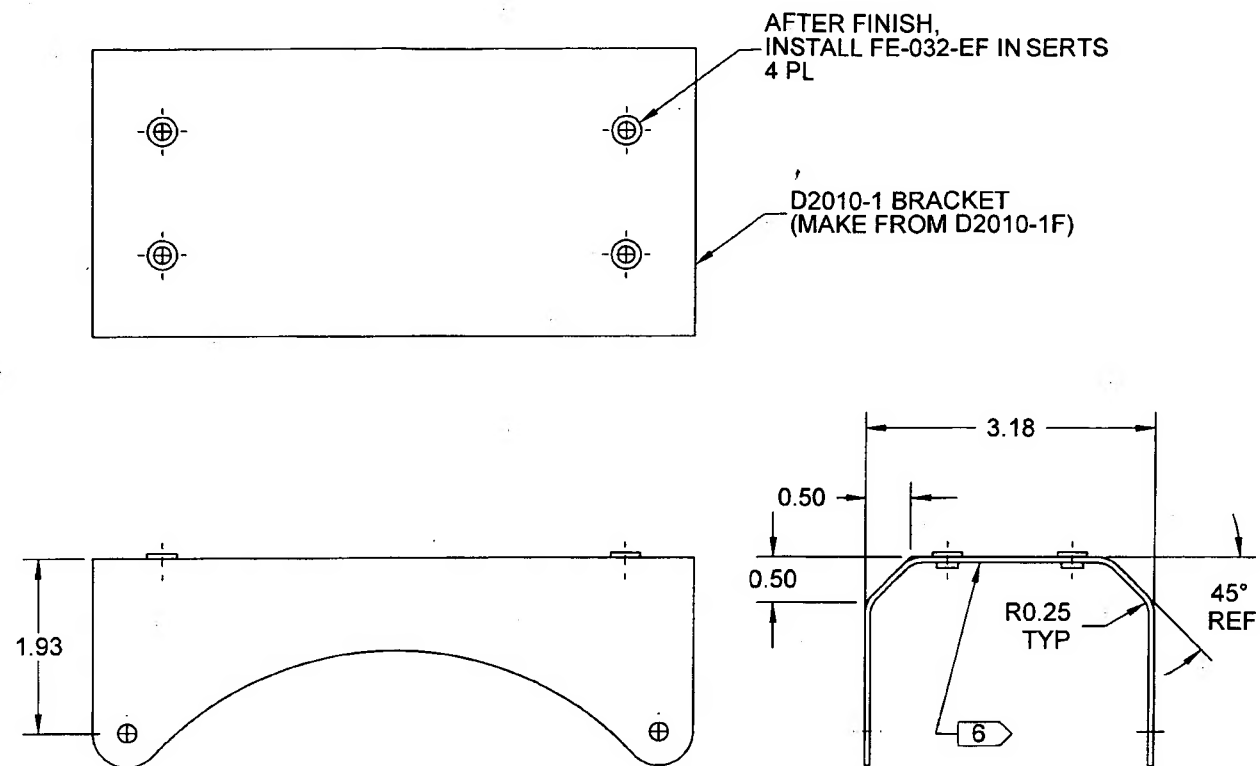
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NO. 40040

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON; TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
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QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



**D2010-1F FLAT PATTERN**



**D2010-101 MIRROR BRACKET**

**NOTES:**

- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: 0.23 lbs

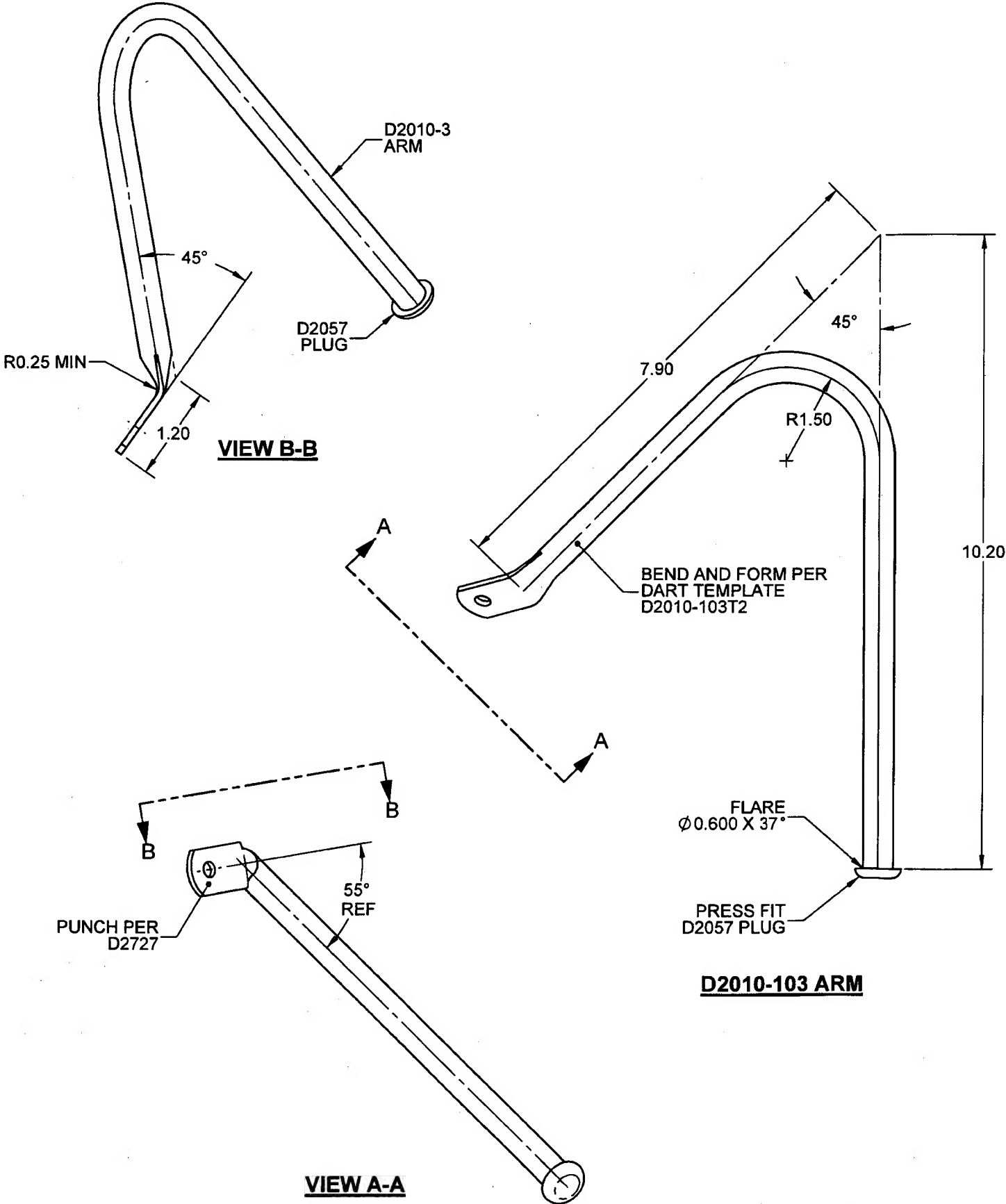
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08.06.10



QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



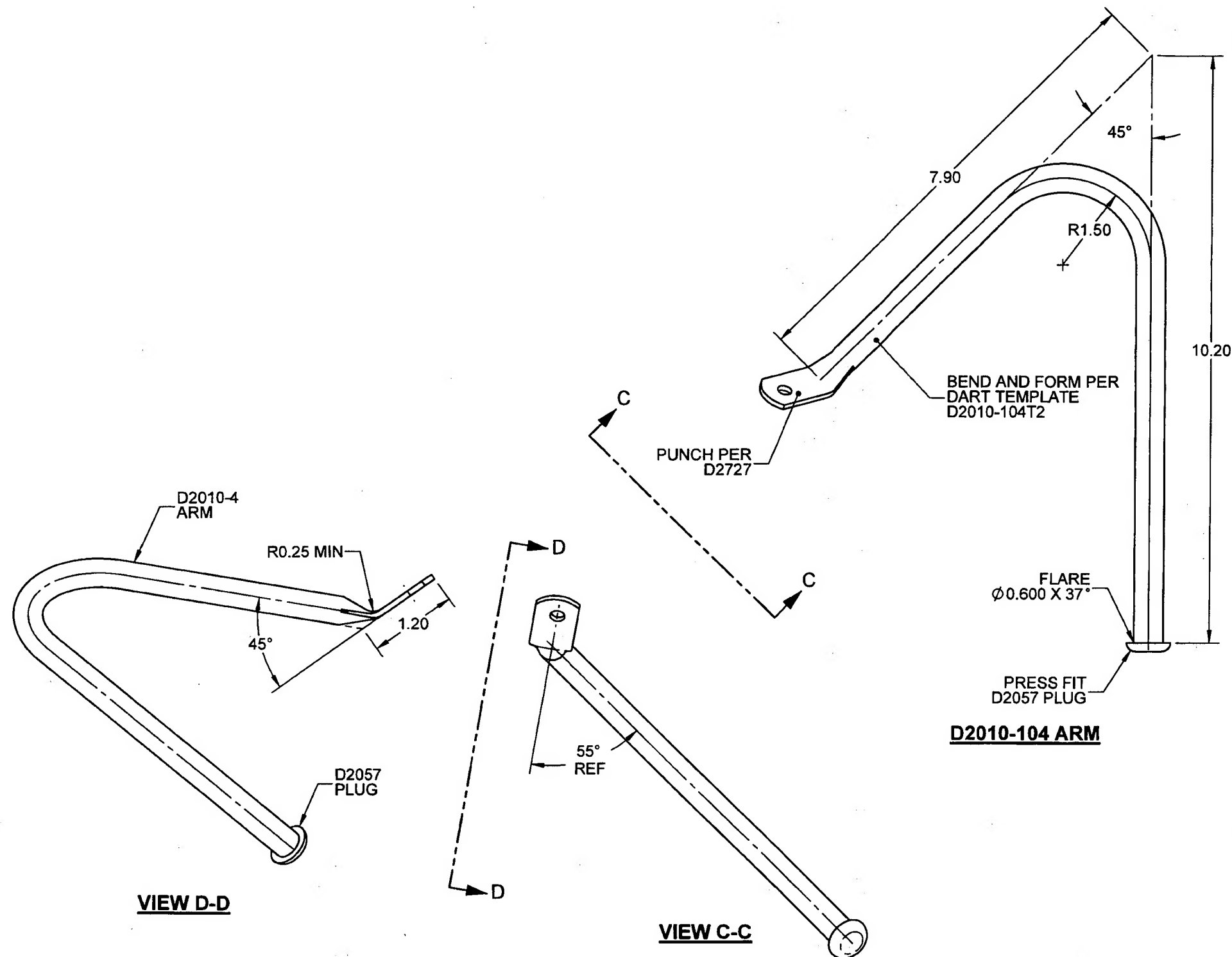
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08-06-10

- NOTES:
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING  
Ø0.500 X 0.049 WALL  
(REF DART SPEC M304TR0.500W.049)  SUBJECT TO AMENDMENT
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART WITHOUT NOTICE  
QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

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QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



**RELEASED**  
08-06-10

- NOTES:**
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\varnothing 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
  - 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

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